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EUROPEAN PATENT APPLICATION

21 Application number: 89303332.4

51 Int. Cl. 4: B 29 D 31/00
 B 32 B 3/12, B 31 D 3/02

22 Date of filing: 04.04.89

30 Priority: 04.04.88 US 177437

43 Date of publication of application:
 11.10.89 Bulletin 89/41

84 Designated Contracting States:
 BE CH DE ES FR GB IT LI LU NL SE

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54 Apparatus and method for making welded honeycomb core.

57 A structural honeycomb core (10,10') made of crystalline thermoplastic to provide corrosion-resistant, heat-resistant, high-impact structure is fabricated by use of welding heads (40) to inter-welding strips (20-27; 20'-27') at spaced locations along their lengths, release substrates (30,50) being interposed between the strips to prevent any one weld from joining more than two of the strips. In a first embodiment, the strips are welded while the crystalline thermoplastic is in its flexible state; and the welded web is expanded and heat-treated to convert the material to its rigid state. In a second embodiment, the strips are corrugated and rigidified prior to welding.

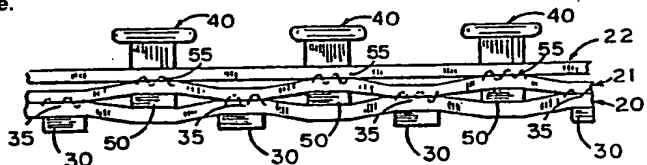


FIG. 8

Descripti n

APPARATUS AND METHOD FOR MAKING WELDED HONEYCOMB CORE

The present invention relates to structural panel-incorporating honeycomb cores and more particularly to an improved core for such panels.

A wide variety of structural panels incorporating honeycomb cores have been developed, particularly for use as aircraft components. The panels typically include an open-cell honeycomb core having thin surface sheets bonded to opposite sides thereof. The assembly results in a low-weight member capable of bearing large compression and shear forces.

The surface or face sheets are commonly made of metals or precured thermoset plastics reinforced with synthetic fibers. Typical sheet thicknesses are in the range .254 to 1.525 mm (0.010 inch to 0.060 inch). Both face sheets are typically bonded to the core using thermosetting adhesives such as epoxies. The assembled core and face sheets are placed in a heated platen press or mould where the adhesive is allowed to cure under heat and pressure. Some thermosetting plastic face sheets are simultaneously cured and bonded to the core in a single operation without the need for adhesive. The uncured plastic resin of the face sheet liquifies initially when heated and wicks up and around the cell edges of the honeycomb which provides the fillets required to attach the face sheets to the core. The amount of pressure and temperature applied depends mainly on the cure characteristics of the resin and is typically in the range of 138 to 1380 kPa (20 pounds per square inch (psi) to 200 psi) and from 93.3 to 315°C (200 degrees Fahrenheit (F) to 600 degrees F).

Metal and thermoset plastic skins are easily damaged by impact and it is therefore desirable to use materials with much better impact resistance. Such materials are available in the thermoplastic resins; however, it is difficult to adhere the cores to the surfaces of these materials--especially the most chemical and heat resistant types such as polyphenylenesulphide (PPS) and polyetheretherketone (PEEK). Consequently, these materials have not gained acceptance for structural honeycomb panels.

The honeycomb cores are fabricated of metal, plastic, and/or paper. Further, the core can be of the "foil/film/sheet", "cast", "extruded", or "heat-formed" type.

Honeycomb fabrication of the "foil/film/sheet" type begins with the stacking of flat or corrugated sheets of web material on which parallel, evenly spaced, adhesive lines called "node lines" are rolled or printed on one or both faces. Cores made from these webs can be further divided into the "expandable" and "corrugated" types.

"Expandable" cores are typically made from flat sheets having node lines on only one side of each web. The sheets are placed on top of each other in such a way that the node lines of each consecutive layer will be positioned between two node lines on the layer below. The completed stack is heated and compressed until the node adhesive has cured and

joined all layers. The resultant block is then sliced into smaller sections and expanded by pulling the outer-most sheets in directions generally perpendicular thereto. The sheets expand away from one another at areas between the node lines, and a hexagonal honeycomb structure is created.

The materials used in the expansion method include a wide variety of metallic foils, plastic films, paper sheets, and woven and non-woven fabrics of plastic, carbon, and glass fibres. Some cores, such as those made from fibreglass fabric and other fibrous materials, are subsequently dipped into water or solvent solutions of plastic resins in order to increase or enhance structural properties. However, the materials used in the fabrication of an expandable core must be capable of being adhesively bonded to one another. Further, relatively soft and thin-gauge materials must be used in order to facilitate expansion of the cured block, especially with limited adhesive strengths. The required expansion forces must not exceed the strength of the node adhesive or the individual layers of core material. As a further consideration, suitable materials tend to return to their relaxed state and must therefore be heated to their softening point and cooled while expanded so that the materials retain the desired hexagonal open-cell shape. The node adhesive must retain sufficient adhesive and cohesive properties to counteract the expansion forced at the required heat setting. This requirement limits the use of the expandable core to low temperature plastics with surfaces that permit bonding.

Expanded cores fabricated of metal are made mostly of thin aluminum foils of less than .152 mm (0.006 inch) thickness. The resultant cores are rather fragile and need to be handled very carefully prior to bonding. Damage to the unbonded cell walls causes the core to become prefailed, meaning that the core in the damaged area will not reach maximum strength levels. The thin foils are also very sensitive to corrosive environments, such as saltwater. Protective coatings are expensive and often of limited value.

Honeycomb cores made from thermosetting resins perform much better when exposed to corrosion. However, they are not impervious to vapour transmission and thus allow the entry of vapour into the honeycomb through the cell walls. Condensation of vapours is believed to cause the corrosion of adjoining aluminium face sheets within the laminated panels.

The "corrugated" process of honeycomb manufacture is normally used to produce products in the higher density range and to permit the use of materials that cannot be expanded as described above. In the corrugation process, a flat sheet or web is corrugated so that each sheet resembles half of the hexagon shape. Adhesive is then applied to the raised portions of the corrugated sheet; and the sheets are placed on top of each other so that all

raised and coated corrugations come into contact with each other creating hexagonally shaped cells. The stacked block is then compressed and heated until the adhesive is cured to join the individual corrugated layers. The corrugated process is also used when cell shapes other than hexagons are desired, for example, to create bell-shaped cells.

The materials used in the corrugated process are typically of greater gauge and bending resistance than the materials used in the expansion process. Typical materials include stainless steel and materials with impregnating resins and binders such as fibreglass and paper. Alternatives to the adhesive joining of the corrugated sheets include spot-welding and solder-dipping, which are typically used with the stainless steels.

The corrugated process is not readily susceptible to automation since the light and often flexible materials used are difficult to support and align during the stacking process. The corrugated sheets tend to nest instead of resting on opposed raised portions. Further, only limited pressure can be used to compress the adhesive films during curing or the cell pattern of the stacked sheets will be distorted. This limited pressure also requires blocks made according to this method to be typically limited in dimension.

"Cast" honeycomb core is fabricated by either 1) pouring a solvent solution of a plastic into a mould resembling a honeycomb pattern or 2) injecting a melted or liquid resin into a mould. Both methods require the material to either dry, cool, or cure inside the mould which typically causes a certain amount of shrinkage. The solid honeycomb core is therefore difficult to unmould. Mould-release provisions are therefore necessary, such as release tapers along the surfaces parallel to the honeycomb cell wall. The resultant cores have tapered cell walls and are restricted to cell diameters sufficiently large to accommodate release tapers. Present typical "cast" cell diameters are at least approximately 12.7 mm (0.5 inch).

"Extruded" honeycomb core is produced by forcing a melted plastic through an extrusion die orifice which resembles either a single honeycomb cell or multiple honeycomb cells. The extrusions are cooled, cut to the desired length, stacked, and either adhesively bonded to each other or fused by solvent cementing. The process requires plastic materials that can be either dissolved by solvents or adhered using adhesives with little bonding pressure and/or heat. The extruded materials cannot be easily modified to include fibre reinforcements into the melt stream exiting the extrusion die. The resultant cores are therefore not as strong as those created using the expanded and corrugated techniques.

The "heat-formed" honeycomb cores resemble the typical hexagonal honeycomb core structure the least. According to this method, a thermoformable plastic sheet is heated to its forming temperature and then formed into a honeycomb-like shape by simultaneously stretching the sheet in opposite directions perpendicular to its initial plane. The stretching tools are either chilled metal pins extending through the sheet or perforated platens which

are adhered to the plastic sheet and pull it apart. The heat-formed method results in cores with cell walls which are not perpendicular to the cell opening and which have varying cell-wall thicknesses. These cores therefore provide only low structural properties.

Now, according to one aspect of the present invention, a method of fabricating structural honeycomb core comprising stacking a plurality of strips one upon the other and connecting each strip to the two adjacent strips at spaced locations, the spaced locations with one of the adjacent strips alternating with the spaced locations with the other of the adjacent strips, is characterised in that the connection step is effected by welding.

According to another aspect of the invention, a method of fabricating a structural honeycomb core comprises superimposing first, second and third strips of thermoplastic with the opposite lateral edges of each aligned, connecting the first and second superimposed strips to one another at first spaced locations along the length of the superimposed strips, connecting the second and third superimposed strips to one another at second spaced locations between the first spaced locations, and expanding the strips to form a honeycomb structure, and is characterised in that the connecting steps are effected by welding at the first and second locations and in that, prior to the connecting step, release substrates are placed adjacent the first locations on the side of the first strip opposite the second strip and release substrates are placed between the second and first strips adjacent the second locations.

According to a third aspect of the invention, a structural honeycomb core comprises a plurality of superimposed strips layered one on top of the other, each of the strips being connected at spaced locations to each of the strips adjacent thereto, and is characterised in that the connections are welds, the spaced locations of the weldments to one of the adjacent strips being offset from the spaced locations of weldments to the other of the adjacent strips.

The present invention overcomes the aforementioned problems and can provide, in a simple and satisfactory manner, a honeycomb core which is corrosion-resistant, impact-resistant, and heat-resistant. The core may be fabricated from thermoplastic resins without the use of thermosetting adhesives. The core structure and method of its fabrication enable the plastic to be reinforced with synthetic, glass, or carbon fibers. More specifically, the core may be fabricated from thermoplastic sheets using either the corrugated or expanded process with the core nodes being welded together. The presently preferred crystalline thermoplastics from which the present core may be fabricated are generally well known to those having ordinary skill in the thermoplastic art. Applicant has recognized that such materials provide the desired characteristics for honeycomb panels and honeycomb cores. For example, thermoplastic cores could be melted to thermoplastic face sheets without the use of adhesive.

However, several problems, the solutions of which are incorporated into the present invention, had to be addressed prior to the use of these materials. First, bond strength using thermosetting adhesives in conjunction with crystalline thermoplastics is insufficient to allow subsequent expansion of the cores at elevated temperatures required to set the core in a rigid configuration. Second, crystalline thermoplastics cannot readily be put into solution for casting and/or solvent cementing. Third, attempts to fabricate honeycomb cores with thermoplastic materials using the cast, extruded, or heat-formed methods preclude the convenient use of fibrous reinforcement which is required to obtain higher structural properties.

After all conventional technologies for interbonding the crystalline thermoplastics proved unsuccessful, Applicant conceived that such sheets could be intersecured by welding the sheets to one another. Welding eliminates the use of thermosetting adhesives, solvents, and other chemical bonding agents.

Broadly, according to a preferred mode of carrying out the present invention, the thermoplastic sheets are welded together at spaced locations while the material is either in a flat or corrugated shape. Most desirably, each sheet or strip is laid in position on the stack and welded at spaced locations to the previous sheet. This process of laying a new sheet in place and welding it at spaced locations to the previous sheet continues until a stack of the desired thickness or number of layers is created. The stack is then heated to the softening temperature of the material and expanded in conventional fashion to create the honeycomb configuration. Cooling to a lower temperature allows the expanded core to rigidify.

The resultant core is less expensive than most metallic cores and is also corrosion, chemical, and impact-resistant. Electrical properties are uniform since only one type of material is used in the assembly.

The invention may be carried into practice in various ways but structural honeycomb cases and their method of fabrication in accordance with the present invention will now be described by way of example with reference to the accompanying drawings, in which:

Fig. 1 is a fragmentary perspective view of a structural honeycomb core fabricated by laying up flat strips or sheets;

Figs. 2-8 illustrate the core at various stages of its manufacturing during the laying up and welding steps; and

Fig. 9 illustrates how the welding process can be adapted to the laying up of corrugated sheets.

A structural honeycomb core constructed in accordance with a preferred embodiment of the invention is illustrated in Fig. 1 and generally designated 10. The core includes a plurality of layers 20-27 which are selectively bonded at nodes 35 and expanded to define a plurality of adjacent hexagonal cells. The appearance of the honeycomb core being described, which is produced in accordance with the

present invention, is similar to the appearance of honeycomb cores generally well known in the art.

The material of which the core 10 is fabricated is a thermoplastic, such materials being generally well known to those having ordinary skill in the thermoplastic art. Suitable materials can be amorphous or crystalline and can be reinforced with fibrous materials and fillers of metal, glass, carbon, ceramic, or other plastics. The thermoplastic presently preferred is a crystalline thermoplastic sold under the trademark VICTREX PEEK by ICI Americas of Dover, Delaware and filled with a woven fibreglass fabric such as style 106 commonly available. Other suitable materials, reinforcements, and fillers will become apparent to those having ordinary skill in the thermoplastic art based upon the described manufacturing process. Generally speaking, any thermoplastic with or without reinforcement and/or filler may be used as long as sheets made from these materials can be fused to themselves at or near the melt temperature of the thermoplastic resin that encapsulates all other reinforcements and fillers.

The core being described is fabricated basically in four phases. The first phase is the preparation of the sheet material for subsequent welding by means of corrugation, surface treatment, or deposition of metallic micron-sized particles at the intended node lines. All or none of these steps may be required, depending on whether corrugated or flat sheets are to be used and also depending upon the source of fusion heat to be selected. The second phase consists of the laying up of layers and welding the various layers together at selected spaced nodes. The third phase comprises heating the stack of sheets to the softening temperature of the thermoplastic. The fourth step includes expanding the heated stack and then cooling the stack to allow the resultant honeycomb structure to rigidify. Phases three and four are not required when precorrugated sheets are used.

Figs. 2 and 3 illustrate the initial laying up step in beginning manufacture of a core. Two thermoplastic sheets 20 and 21 are superimposed or laid on one another throughout their length. As illustrated, the ends of each strip are broken to show indeterminate length. The length of the strips is not important to the present invention. The bottom strip 20 includes a pair of lateral edges 20a and 20b, and likewise the top strip 21 has a pair of lateral edges 21a (not visible) and 21b. When the strips are superimposed on one another, the lateral edges 20a and 21a and also 20b and 21b are aligned so that the resultant expanded core will have a relatively flat or uniform surface. A plurality of foil strips 30, or other release substrates, is provided at spaced locations under the bottom strip 20. Each foil strip 30 is at least as long as, and preferably longer than, the width of the strips 20 and 21 so that the foil strip extends from either side thereof. Further, the width of each release substrate 30 is at least approximately 1/4 of the centre-to-centre distance between adjacent foils. This spacing is conventional to create an expanded core having regularly shaped hexagonal cells.

Figs. 4 and 5 illustrate the first welding step in the

fabrication of the core. The strips 20 and 21 are welded together at evenly spaced locations or nodes above the foil strips 30. A plurality of uniformly spaced ultrasonic welding heads 40 is brought down into contact with the top strip 21 so that each head is generally aligned with one of the foil strips 30. Ultrasonic welders are generally well known to those having ordinary skill in the ultrasonic welding art and consequently the apparatus on which welding heads 40 are mounted will not be described. Suffice it to say that the welding heads 40 are each capable of providing an ultrasonic weld to the strips 20 and 21 when positioned thereagainst. Preferably, the width of each weld is 1/4 of the centre-to-centre distance between welding heads—such dimensions being conventional to create regular hexagonal cells.

At least three types of known welding head configurations can be used in performing the welding steps. As presently preferred, ultrasonic welding is used wherein the welding horns heat the material through high-frequency vertically reciprocating motion. An alternative welding technology includes the deposition of metallic ferrous particles on the node lines; and incorporating induction coils within the welding heads to cause the metallic particles and material to be heated through the action of a magnetic field. Such induction welders are sold by Hellerbond Technology of Columbus, Ohio and EMA Bond Inc. of Englewood, New Jersey. As a third alternative, an electrically heated welding head can be used to transfer heat to the plastic material.

After the first welding operation between strips 20 and 21 is complete, the welding heads are withdrawn and an additional strip 22 is laid in position as illustrated in Figs. 6 and 7. As with all the strips, the lateral edges of the strip 22 are aligned with the lateral edges of the strips 20 and 21. Additionally, foil strips or other release substrates 50 are inserted between strips 20 and 21 at spaced locations between welded nodes 35. The foil strips 50 are generally identical to the foil strips 30. Consequently, the width of each of the foil strips 50 is approximately 1/4 of the centre-to-centre distance between foil strips 30 or the centre-to-centre distance between the foil strips 50. Further, each foil strip 50 is approximately midway between two foil strips 30 of the previous layer.

After the strip 22 is placed in position, the welding heads 40 are brought down into engagement with the strip 22 at evenly spaced locations above and aligned with the release strips 50. The welder is then actuated to create an ultrasonic weld at nodes 55, each of which has a width generally 1/4 of the centre-to-centre distance between the welding heads. As noted above, the welding heads 40 are preferably fixedly spaced from one another in an appropriate supporting structure. The same welding heads can be used to weld alternating node layers 35 and 55 by alternately shifting the weld heads back and forth 1/2 of the centre-to-centre distance between the heads for each layer.

As illustrated in Fig. 8, each strip such as 21 is welded to each of the adjacent strips 20 and 22. The foil release strips 30 and 40 insure that only two

adjacent layers or strips will be joined together during each welding operation. The weld nodes 35 between the strips 20 and 21 alternate along the length of the strips with the weld nodes 55 between the strips 21 and 22. Consequently, the length of each strip 21 is approximately 1/2 occupied by weld nodes 35 and 55 and 1/2 free.

The sequence illustrated in Figs. 6-8 of placing another crystalline thermoplastic strip in position, inserting release substrates, and welding the new strip at spaced locations is repeated until a stack having the desired thickness or number of layers is created. Typically, the release strips 30 and 50 are withdrawn from the assembly after all welding is complete. Alternatively, the release strips can be removed when the stack has increased in size so that no danger of ultrasonic bonding is created at the layers from which the release strips are removed. Perhaps the easiest means of removing the release strips is permitting them to fall from between the cells as the honeycomb core is expanded.

After all welds are complete, the assembly is expanded to create the regularly shaped hexagonal open cells seen in Fig. 1. It is conceivable that one portion of the web could be expanded while a separate portion of the web is still being supplemented with additional thermoplastic strips.

After expansion is complete, the expanded core is heat-treated to thermally set or otherwise rigidify the crystalline thermoplastic strips. Depending on the material used for the strips 20 to 27, other rigidifying processes may be used. For example, it may be desirable to chemically treat the strips to create rigidity or to dip-coat the expanded core in a material which subsequently rigidifies as a coating.

The core described above can then be used in fabricating structural panels in conventional fashion. Specifically, surfacing sheets or layers (not shown) are applied to the two opposite sides of the honeycomb core structure to create a panel. The panel face sheets, if made of the same material as the core, or if fusible to the core material, could be melted to the core as well without the use of epoxies or other adhesive or bonding agents.

Fig. 9 illustrates the use of the present invention in fabricating corrugated cores 10'. In contrast to the layers 20 and 21 described above, the layers 20' and 21' are corrugated prior to welding. The raised areas 22' of adjacent sheets are aligned with one another and welded together using welding techniques as described above. The release substrates 50' are as high (as viewed in Fig. 9) as one of the cells and are as wide as one of the cell walls to facilitate stacking and maintain cell shape during welding.

The described core enables the fabrication of structural panels which are particularly well suited to high-temperature applications. The crystalline thermoplastic is relatively inexpensive as compared to metallic cores which have been previously required in high-temperature applications. Further, the described material is noncorrosive and impact-resistant.

It is also anticipated that various layers of the core could be fabricated of different thermoplastics; as long as the different thermoplastics fused to each

other. For example, it may be desirable to use different materials to improve electrical characteristics. For example, a core could be fabricated of alternating layers of polyetherimide (PEI) resin sold under the trademark ULTEM by General Electric Company with alternate layers being fabricated of polyethersulfone (PES) resin sold under the trademark VICTREX PES by ICI Americas of Dover, Delaware.

The above description are those of preferred embodiments of the invention. Various alterations and changes can be made without departing from the invention.

Claims

1. A method of fabricating structural honeycomb core (10;10') comprising stacking a plurality of strips (20;20') one upon the other and connecting each strip to the two adjacent strips at spaced locations (35), the spaced locations with one of the adjacent strips alternating with the spaced locations with the other of the adjacent strips, characterised in that the connection step is effected by welding.

2. A method according to claim 1 in which the strips are fabricated of a material having a flexible state and a rigid state, and further comprising expanding the welded strips as necessary to form a honeycomb configuration, and converting the strips from their first state to their second state while held in the honeycomb configuration to rigidify the strips in the honeycomb configuration.

3. A method according to claim 2 in which the said material is changed from its flexible to its rigid state by thermal treatment.

4. A method as claimed in any of claims 1 to 3 in which the stacking step includes individually adding strips on the accumulating stack, and the welding step includes welding each individual strip after it is added to the stack.

5. A method according to any of claims 1 to 4 in which the welding step includes inserting release substrates (30,50;50') in between the strips at the spaced locations to prevent any one weld from joining more than two of said strips.

6. A method according to any of claims 1 to 5 in which the strips are corrugated prior to the welding step.

7. A method according to any of claims 1 to 6 in which material is a crystalline thermoplastic which, preferably, is fibre reinforced.

8. A method of fabricating a structural honeycomb core (10;10') comprising superimposing first, second and third strips (20;20') of thermoplastic with the opposite lateral edges of each aligned, connecting the first and second superimposed strips to one another at first spaced locations (35) along the length of the superimposed strips, connecting the second and third superimposed strips to one another at second spaced locations (35) between the first

spaced locations, and expanding the strips to form a honeycomb structure, characterised in that the connecting steps are effected by welding at the first and second locations and in that, prior to the connecting step, release substrates (30,50;50') are placed adjacent the first locations on the side of the first strip opposite the second strip and release substrates are placed between the second and first strips adjacent the second locations.

9. A method according to claim 8 which includes repeating the superimposing steps, the placing steps and the welding steps repeatedly to create a multiplicity of welded layers of the strips prior to the expansion step.

10. A method according to claim 8 or claim 9 in which the thermoplastic is crystalline thermoplastic.

11. A method according to claim 10 in which the crystalline thermoplastic is fibre reinforced.

12. A method according to any of claims 8 to 11 in which the strips are fabricated of a material which is relatively flexible in a first state and is relatively rigid in a second state, the strips being welded while in the first state and subsequently converted to the second state.

13. A structural honeycomb core (10;10') comprising a plurality of superimposed strips (20;20') layered one on top of the other, each of the strips being connected at spaced locations (35) to each of the strips adjacent thereto, characterised in that the connections are welds, the spaced locations of the weldments to one of the adjacent strips being offset from the spaced locations of weldments to the other of the adjacent strips.

14. A structural honeycomb core according to claim 13 in which the layers are corrugated.

15. A structural honeycomb core according to claim 13 or claim 14 in which the material is a crystalline thermoplastic.

16. A structural honeycomb core according to claim 15 in which the crystalline thermoplastic is fibre-reinforced.

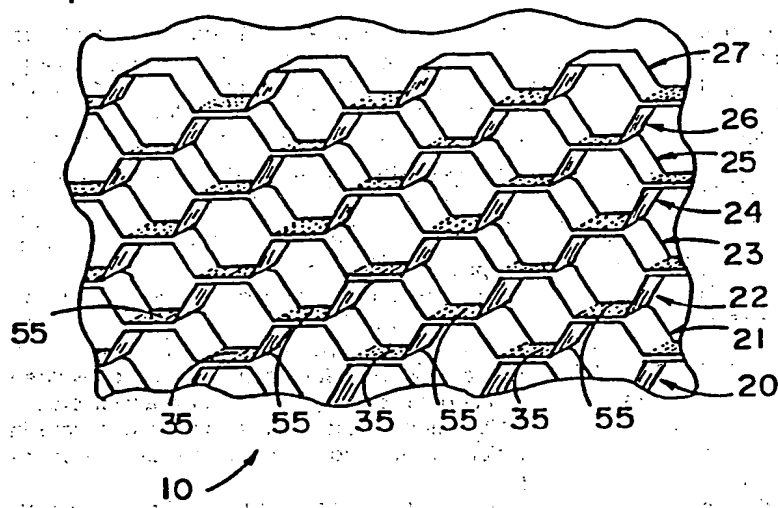


FIG. 1

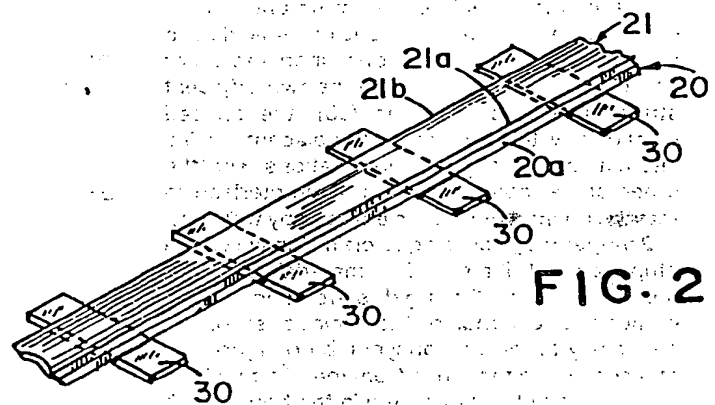


FIG. 2

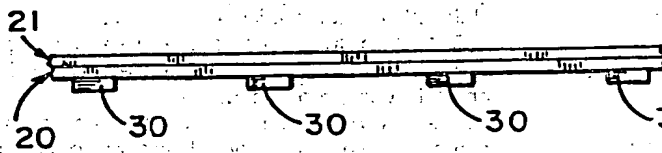


FIG. 3

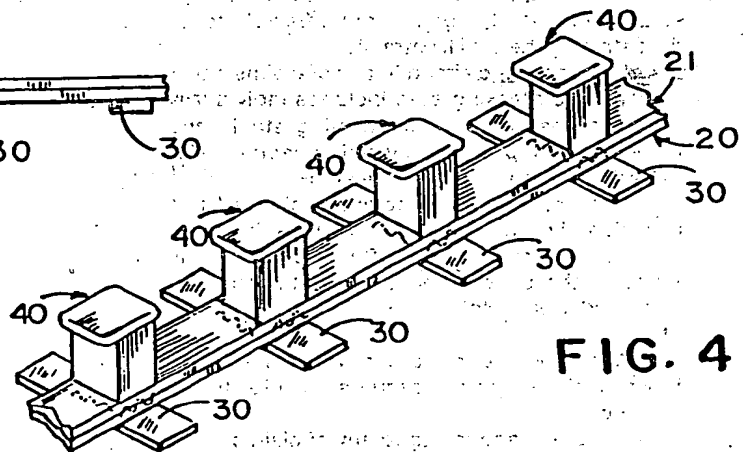


FIG. 4

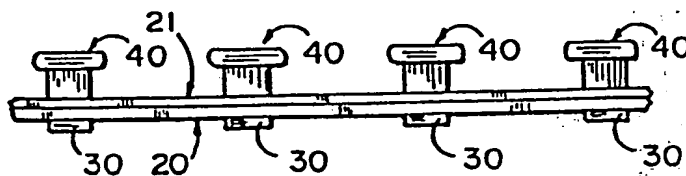


FIG. 5

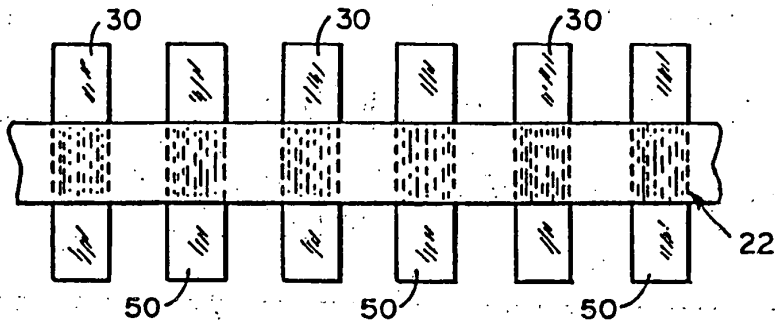


FIG. 6

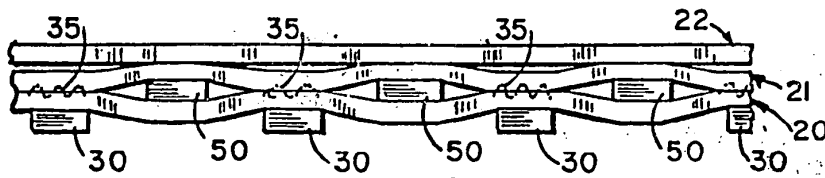


FIG. 7

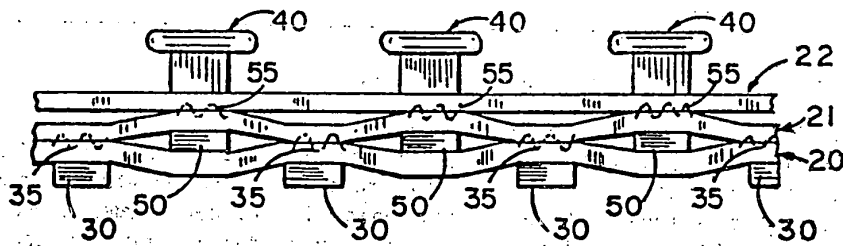


FIG. 8

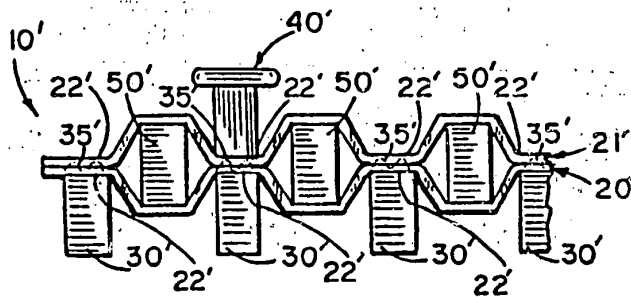


FIG. 9

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 336 722 A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 89303332.4

(51) Int. Cl.⁵: **B29D 31/00, B32B 3/12,
B31D 3/02**

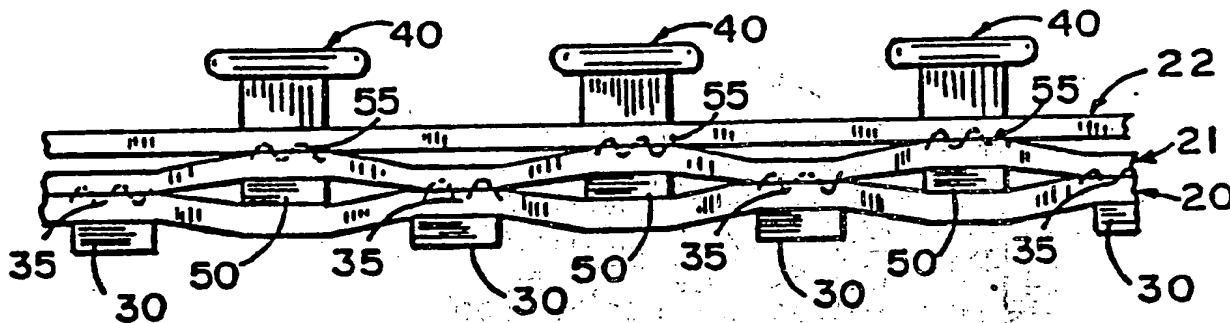
(22) Date of filing: 04.04.89

(30) Priority: 04.04.88 US 177437

(43) Date of publication of application:
11.10.89 Bulletin 89/41(84) Designated Contracting States:
BE CH DE ES FR GB IT LI LU NL SE(88) Date of deferred publication of the search report:
21.08.91 Bulletin 91/34(71) Applicant: **PLASCORE, INC.** (a Michigan corporation)
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Metcalf et al
Kilburn & Strode 30 John Street
London, WC1N 2DD(GB)(54) **Apparatus and method for making welded honeycomb core.**

(57) A structural honeycomb core (10,10') made of crystalline thermoplastic to provide corrosion-resistant, heat-resistant, high-impact structure is fabricated by use of welding heads (40) to inter-welding strips (20-27; 20'-27') at spaced locations along their lengths, release substrates (30,50) being interposed between the strips to prevent any one weld from

joining more than two of the strips. In a first embodiment, the strips are welded while the crystalline thermoplastic is in its flexible state; and the welded web is expanded and heat-treated to convert the material to its rigid state. In a second embodiment, the strips are corrugated and rigidified prior to welding.

**FIG. 8**
EP 0 336 722 A3



European
Patent Office

EUROPEAN SEARCH REPORT

Application Number

EP 89 30 3332

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X,Y	US-A-4 174 987 (BELVIN,PERRY,WATKINS) * column 8, line 15 - column 8, line 48; figure 7 ** column 6, line 63 - column 6, line 64 *	1,7,8, 10-16, 2-5,9	B 29 D 31/00 B 31 D 3/02 B 32 B 3/12
X	US-A-4 478 659 (HALL) * abstract *	1,7	
X	FR-A-2 124 167 (LOUSTAU) * page 3, line 9 *	1,7	
X	US-A-3 366 525 (JACKSON) * claim 1 *	1,7	
X	US-A-3 134 705 (MOELLER) * column 2, line 51 - column 2, line 55; claim 1; figure 2 *	1,6,7	
Y	US-A-3 810 800 (DOLL)	2,3	
Y	CH-A-4 571 19 (PIMEX ANSTALT,SCHAAN)	4,5,9	
A	US-A-3 547 751 (MORGAN)	1	TECHNICAL FIELDS SEARCHED (Int. Cl.5)
A	US-A-3 379 594 (BRUDER)	1	B 29 D B 31 D
A	US-A-3 673 058 (JACKSON,GARRETT)	1	
The present search report has been drawn up for all claims			
Place of search		Date of completion of search	Examiner
The Hague		26 June 91	ROBERTS P.J.
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